

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009137**Date Inspected:** 23-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG Trail Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) S. Manjunath. Math was present during the times noted above for observations relative to the work being performed.

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 5AE

This Quality Assurance (QA) Inspector witnessed final tension verification for Upper and Lower Chevron Brace at North (Cross Beam) side and South (Bike Path) side at PP 29, PP 30 and PP 31 for Segment 5AE. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used are M22x70 RC Lot No. DHGM220004 and final Torque required was 453 N-m,

Bolt sizes used are M22x75 RC Lot No. DHGM220005 and final Torque required was 473 N-m and

Bolt sizes used are M22x80 RC Lot No. DHGM220050 and final Torque required was 486 N-m.

Manual Torque wrench was been used with Serial No. X02-584 and Hydraulic Wrench was been used for inaccessible areas with Model No. MP532-2 and with Serial No. PW090331002.

Note: Verified the flatness for the Splice Plate and observed gap during the measurement at Segment 5AE Lower

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Chevron Splice North(Cross Beam) East side of splice at PP 29, informed the same to the Caltrans Engineer Mr. Aaron Prchlik and he witnessed physically and accepted it for more comprehensive information please refer the pictures attached below.

Segment 5BE

This Quality Assurance (QA) Inspector witnessed final tension verification for Upper and Lower Chevron Brace at North (Cross Beam) side and South (Bike Path) side at PP 32, PP 33 and PP 34 for Segment 5BE. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used are M22x70 RC Lot No. DHGM220004 and final Torque required was 453 N-m,

Bolt sizes used are M22x75 RC Lot No. DHGM220005 and final Torque required was 473 N-m and

Bolt sizes used are M22x80 RC Lot No. DHGM220050 and final Torque required was 486 N-m.

Manual Torque wrench was been used with Serial No. X02-584 and Hydraulic Wrench was been used for inaccessible areas with Model No. MP 532-2 and with Serial No. PW090331002.

Segment 5CE

This Quality Assurance (QA) Inspector witnessed final tension verification for Upper and Lower Chevron Brace at South (Bike Path) side for PP 35 and PP 36 and Upper Chevron at PP 35 and PP 36 North (Cross Beam) side the Lower Chevron not been offered by ZPMC and ABF for Segment 5CE. Inspected 10% on a random basis and found the tension to be in general compliance.

Bolt sizes used are M22x70 RC Lot No. DHGM220004 and final Torque required was 453 N-m,

Bolt sizes used are M22x75 RC Lot No. DHGM220005 and final Torque required was 473 N-m and

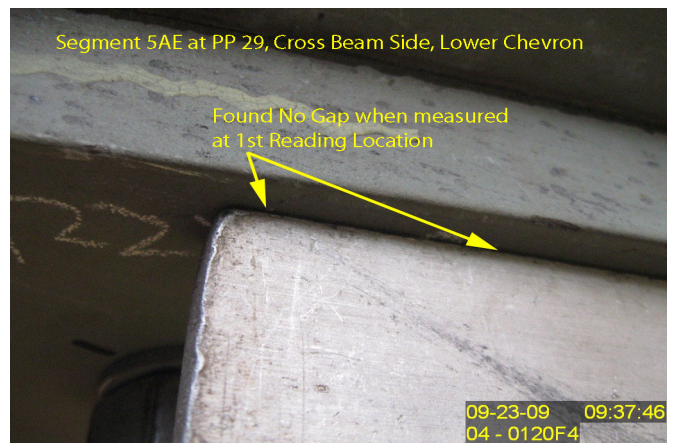
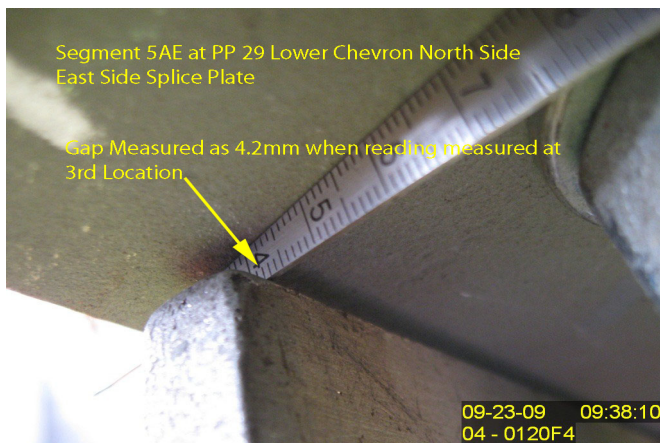
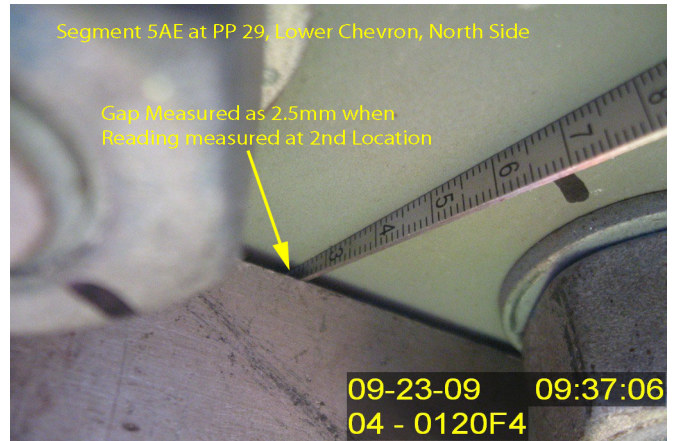
Bolt sizes used are M22x80 RC Lot No. DHGM220050 and final Torque required was 486 N-m.

Manual Torque wrench was been used with Serial No. X02-584 and Hydraulic Wrench was been used for inaccessible areas with Model No. MP 532-2 and with Serial No. PW090331002.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer